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D4893-1

Job Sheet 183257



Part No: D4893-1

Job Qty: 2 ea

Part Name: Hard Point Adapter, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-3		mar L 18/10/18
100	Bandsaw	2 pcs	10/5/18	10/5/18	0.00	0.00	Bandsaw1		"
110	CNC Vertical Machining	2 pcs	10/5/18	10/5/18	0.24	2.67	HAAS1-5		"
130	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		De 18-10-21
140	HandFinish	2 pcs	10/5/18	10/5/18	0.00	0.20	HandFinish1		DJR 18/10/22
150	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		18-10-22
151	Powdercoat	2 pcs	10/5/18	10/5/18	0.00	0.09	Powdercoat1		18-10-22
155	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC3		OCT 23 2018 68
170	Packaging	2 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		OCT 30 2018 9-89
180	QC21-SA	2 Ea	10/5/18	10/5/18	0.00	0.00	QC21		

Part Op 100 - Cut blank:3.375" long

Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893

151 - MASK AS PER NOTE 9

M. 138951 START: 3:35 OUT: 3:00 FINISH: 4:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X05.000	6061T6 Bar 2.00 X 5.000	.5800 ft (.29 ea)	90-Start up Operation	SC 3668

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X05.000	1	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, LH	72.000Degrees $\pm$ 0.500	72.500 71.500	Angle	
2	Hardpoint Adaptr, LH	1.500Inches $\pm$ 0.030	1.530 1.470		
3	Hardpoint Adaptr, LH	0.030Inches $\pm$ 0.030	0.060 0.000		
4	Hardpoint Adaptr, LH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

5	Hardpoint Adaptr, LH	2.450Inches ± 0.030	2.480 2.420	
6	Hardpoint Adaptr, LH	1.300Inches ± 0.030	1.330 1.270	
7	Hardpoint Adaptr, LH	0.750Inches ± 0.030	0.780 0.720	
8	Hardpoint Adaptr, LH	2.500Inches ± 0.030	2.530 2.470	
9	Hardpoint Adaptr, LH	1.250Inches ± 0.030	1.280 1.220	
10	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220	Radius
11	Hardpoint Adaptr, LH	0.500Inches ± 0.030	0.530 0.470	
12	Hardpoint Adaptr, LH	0.129Inches $+ 0.005$ $- 0.001$	0.134 0.128	Diameter
13	Hardpoint Adaptr, LH	0.204Inches $+ 0.005$ $- 0.001$	0.209 0.203	Diameter
14	Hardpoint Adaptr, LH	1.500Inches ± 0.030	1.530 1.470	
15	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970	
16	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970	
17	Hardpoint Adaptr, LH	0.130Inches ± 0.030	0.160 0.100	Radius
18	Hardpoint Adaptr, LH	0.830Inches ± 0.030	0.860 0.800	
19	Hardpoint Adaptr, LH	0.100Inches ± 0.030	0.130 0.070	
20	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle
21	Hardpoint Adaptr, LH	1.750Inches ± 0.030	1.780 1.720	
22	Hardpoint Adaptr, LH	1.460Inches ± 0.030	1.490 1.430	
23	Hardpoint Adaptr, LH	1.650Inches ± 0.030	1.680 1.620	
24	Hardpoint Adaptr, LH	4.000Inches ± 0.030	4.030 3.970	
25	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220	
26	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle
27	Hardpoint Adaptr, LH	0.750Inches ± 0.010	0.760 0.740	
28	Hardpoint Adaptr, LH	1.015Inches ± 0.010	1.025 1.005	Diameter

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Sta _____

Description Work Order _____

AGAINST DEPARTMENT/PROCESS

Engineering ☐
Quality ☐
Other ☐

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

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Container No: S118935
Part: D4893-1
Job No: 183257
Serial No/Batch: S118935
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's
Date: 10/16/18

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐
Set-up	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐
Power Loss/Surge	☐
Folio/Program	☐
Grain	☐
Weld	☐
Wrong Stock Pulled	☐
Out of Sequence	☐
Off-set	☐
Mislabeled	☐
Fit/Function	☐
Misaligned/off center	☐

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

OTHER : _____